

Date: Thursday, 13/11/2008 9:07:37 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LARGE SHELF		
Job Number	: 43111			Part Number	: D32521		
Estimate Number	: 10881			Drawing Number	: D3252 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 20/11/2008		
Previous Run	: 43111			Qty:	2	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.11.13</u>						
Comment	: Est. B 04.10.26 D3252-1 no longer made in-house est c 08.11.13 in-house ec verified: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
Comment: Qty.: 2.2743 sf(s)/Unit Total : 4.5486 sf(s) 2024-T3 .063 sheet batch: <u>109463</u> <u>HR 8-11-13</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3252 Dwg Rev: <u>A</u> <u>HR 8-11-13</u> Prog Rev: <u>A</u>		
<u>2</u> 2-Deburr if necessary <u>HR 8-11-13</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>HR 8-11-13</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>S 08/11/14 (2)</u>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<u>SB 08/11/18</u>		
Bend as per dwg D3252		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 9:07:37 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE SHELF

Job Number: 43111

Part Number: D32521

Job Number:



Seq.#: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sagul 18 (X2)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

08-11-16 X2

8.0 POWDER COATING

POWDER COATING



M10S642

(2X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 3:30

OVEN TEMPERATURE: 320 °F

FINISH TIME: 4:00

MF 08/11/19

(2)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/11/20

(2)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



(2X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 146

6/11/20

SOP

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4311
Description: Large Shelf (Dual Battery Rack)	Part Number: D3252-1
Inspection Dwg: D3252 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

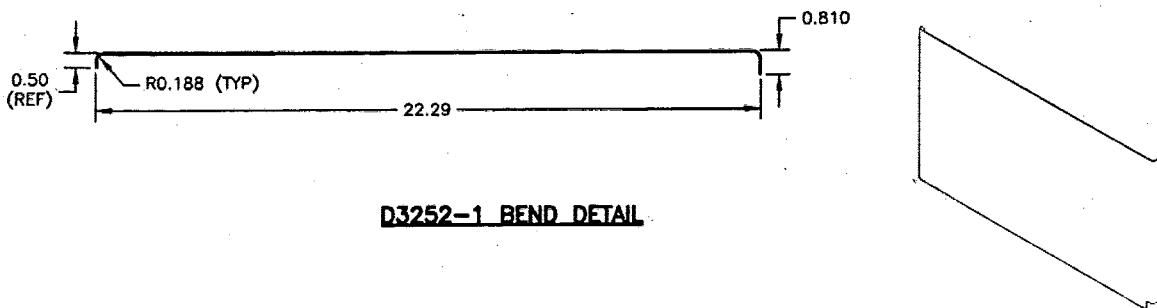
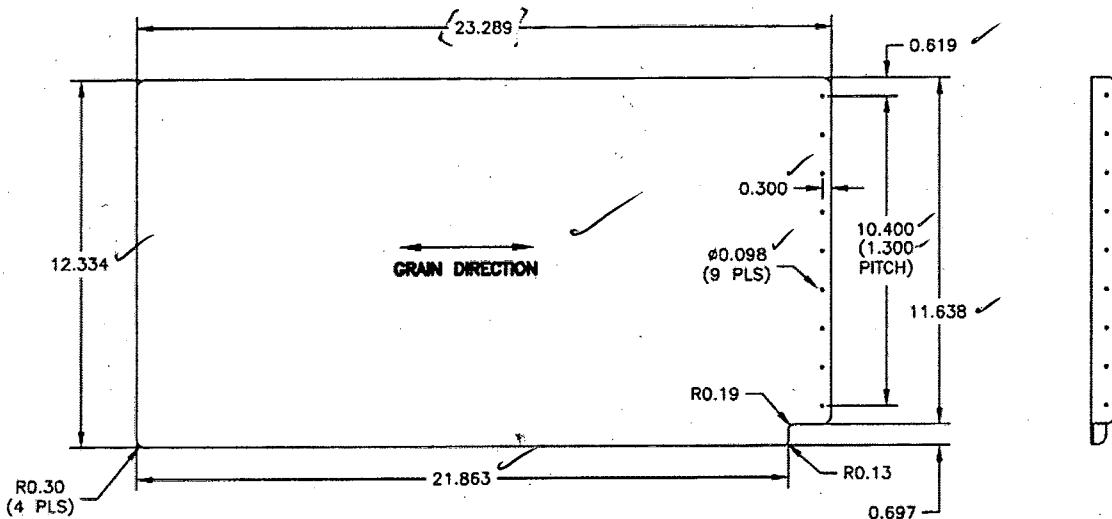
X First Article Prototype

Measured by:	HB	Audited by:	✓	Prototype Approval:	N/A
Date:	8-11-13	Date:	08/11/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	P/O D205-579-015	KJ/JLM ✓ <i>[Signature]</i>

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>GP</i>	APPROVED <i>RF</i>	DRAWING NO. D3252	REV. A	SHEET 1 OF 1
DATE 04.04.06	TITLE LARGE SHELF (DUAL BATTERY RACK)			SCALE 1:6
A	04.04.06	NEW ISSUE		

RELEASED
04.05.04
**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4311*